

Date: Thursday, 5/4/2006 1:09:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR ADAPTER
 Job Number : 27025
 Estimate Number : 12132
 P.O. Number : NIA Part Number : D34763
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3476 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : 25689 Material : NIA
 Written By : *See Comment Below* Due Date : 5/28/2006 Qty: 10 Um: Each
 Checked & Approved By : *06-05-05*
 Comment : Est Rev:A New Issue 06-01-31 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1197 For D3476-3S

Spin as per Dwg D3476

Possible Supplier: SIEG

Material release note is required

C 206/05/09 10

2.0 D34763S DOME, SPINNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 scoop outlet

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 206/14/06 10

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Layout Hole Position Using Dt8844 Template

2-Drill 2.250" as per Dwg D3476

FF 06-07-04 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 1:09:51 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 27025

Part Number: D34763

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Flare as per Dwg D3476 Using DT8845 A&B

4-Deburr if Required

FF 06-07-05

8
10
PTO

6.0

QC5

INSPECT WORK TO CURRENT STEP



Job 0705

8

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 356

4/6/2/6

DB-

(5)

8.0

DC

DOCUMENT CONTROL



(8)

Comment: DOCUMENT CONTROL

Inspection Level 21


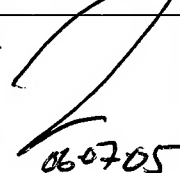

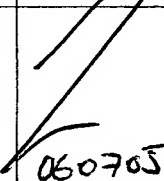
06/07/07

Job Completion



06/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-05	5	2 Blower motor adapter flange cracked at flaring		Destroy, No more to Replace	FF 06.07.05	 060705	 060705	 060705

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/07

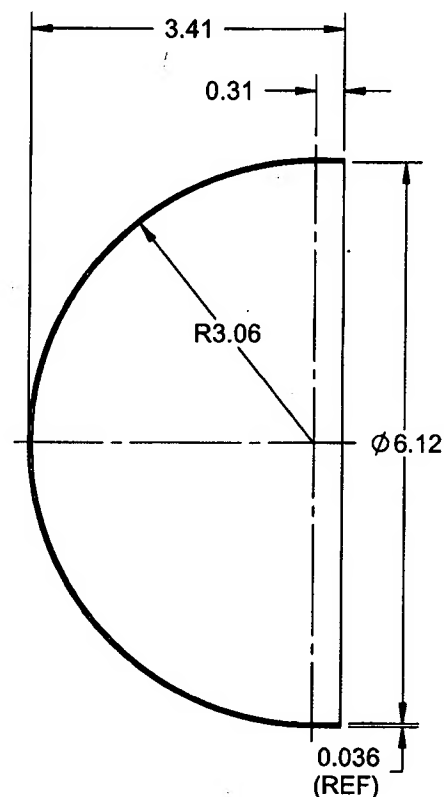
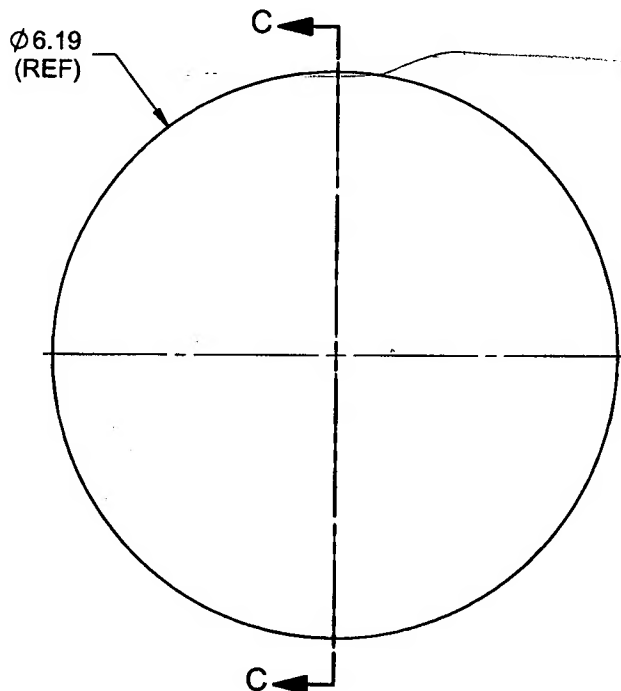
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 4 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED
06.04.03 *[Signature]*



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27025

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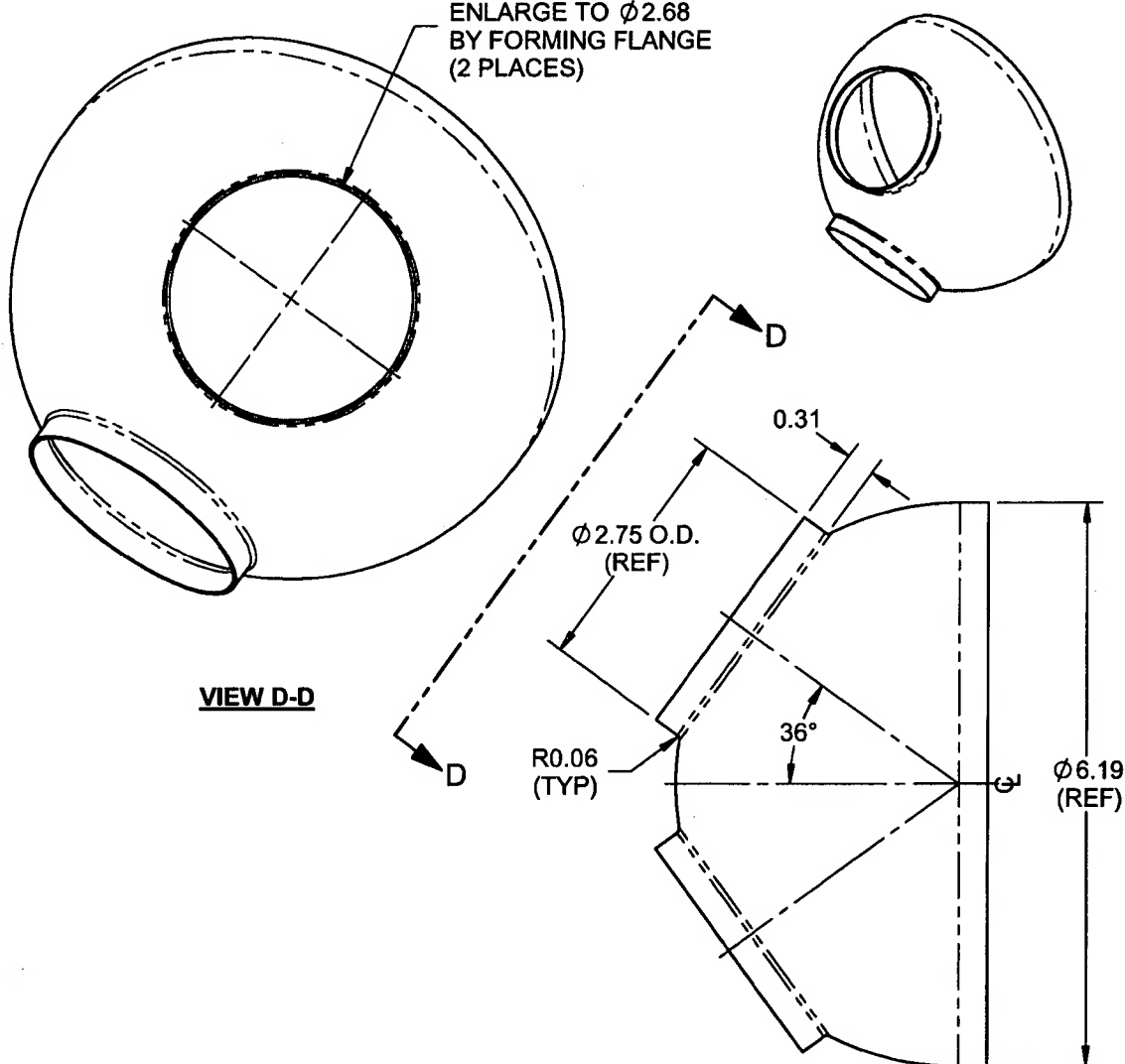
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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3476	REV. A SHEET 5 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

06.04.03

CUT $\phi 2.25$ HOLE,
ENLARGE TO $\phi 2.68$
BY FORMING FLANGE
(2 PLACES)

**D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Sieg's Manufacturing ltd.

604 530-7455 fax 604 530-7490
6238-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

DATE: June 9/06..

CUSTOMER: Dart Aerospace

INVOICE #: 30308 SUPPLIER #: _____

DESCRIPTION OF INSPECTION: _____

[illegible]

NOTES OF INSPECTION: _____

NOTES OF REJECT: _____

02/23/06 THU 14:14 FAX 6045209808
Mill Test Report

ABSTRACT INT'L METALS

MILIN: Arla

2001
Page 1 of 1



MILL TEST REPORT

TA CHEN INTERNATIONAL, INC.
www.tachen.com

This MTR contains 1 page (Page: 1)

MTR#: ACCL10542

Item#: 20GA48120316L2B

 ThyssenKrupp Nirosa Ein Unternehmen von ThyssenKrupp Steel AG		ABNAHMEPRUEFZEUGNIS 3.1 INSPECTION CERTIFICATE 3.1 CERTIFICAT DE RECEPTION 3.1 EN 10204		Zeugnis-Nr.: 051101471 Certificate No.: N° de certificat: <i>ACCL10542</i> Datum: 20.04.2005 Date: Day:							
47704 Krefeld		Postfach		THYSSENKRUPP NIROSTA							
THYSSENKRUPP NIROSTA 2275 HALF DAY ROAD, SUITE 160 USA- BANNOCKBURN, IL 60015 USA		Bestell-Nr.: OC 00002449 - PO L13612 Order-Nr.: Commande N°:		Umsatz-Nr.: 278140 Our Order No.: Notre commande							
Lieferanten-Nr.: 86437223 Delivery Note No.: Avis d'expédition N°:		Zeichen & Bestätigung Inspector's stamp Paten de l'expert									
Erzeugnisform: Produkt: Werkstoff: Qualität: Normen:		Produkt: TYPE 316L 316 L <i>D3476-3</i>		Lieferbedingungen/Terms of delivery/Conditions de livraison: ASTM A 240/A 240M-04a ASME SA 240 Sec. II Part A Ed.04 ASTM A 480/A 480M-04 ASME SA 480/SA-480M 01 ASTM A 688-03 SAE AMS 5507 F SAE AMS 5524 K							
Position Horn Piste	Stückzahl Quantity Métrique	Gewicht/Masse LBS	Maße/Produkt dimensions/Dimensions du produit Inch			Material-Art Mat. type Matériau	Schweiß-Nr. Weld No. Coudre N°	Lot-/Batch-Nr. Lot-/Batch No. Lot-/Batch N°	Anmerkung Finish Fin		
10	629	36953	0,0350 x 48,0000 x 120,0000			AOD		22056	3C2B		
Schweiß-Nr. Weld No. Coudre N°	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	N %	Cu %	
484447	0,02	0,37	0,86	0,029	0,001	16,85	2,02	10,54	0,037	0,23	
Probe Number Test No. Essai	Lot-/Batch-Nr. Lot-/Batch No. Lot-/Batch N°	Rp0,2 %	Rp1% %	Rm %	A2° %	HV	KO	GL/BT %			
596 A	22056 00	47555	51325	91195	49,8	163,0	10,0	17,0			
596 E	22056 00	48135	51780	91920	50,0	164,0	10,0	17,0			
Probentyp auf Werkstoff QUER	KO Korngröße / Grain Size nach ASTM E 112 GL/BT Glanz bei 20 Grad (BRIGHTNESS TEST-USA)										
Vervorschauungsprüfung (Spektralanalyse)/Test of identity (spectrum analysis)/Contrôle d'identification (analyse spectrale) Maße - Oberflächen/Dimensions - Surfaces/Dimensions - Surfaces Prüfung auf Intermetall, Karos/Test of intermetal, caros/Test de caros, intermetall						I.O. L.O. O.B.		8892721 8892723 8892741 8892747 8892748 8892749 8892750 8892760 8892762 8892763 8892765			
ThyssenKrupp Nirosa GmbH DIESES ZEUGNIS WURDE VOM RECHNER ERSTELLT WERK KREFELD, ABNAHME BUTZEN ABNAHMEBEAUFTRAGTER INSPECTION REPRESENTATIVE TEL: 02151-833447 FAX: 02151-834106						Frei von Quecksilber / free of mercury NO WELD REPAIR WÄRMEBEHANDLUNG : 1050 GRAD C / LUFT TRAITEMENT THERMIQUE : 1050 GRAD C / AIR HEAT - TREATMENT : 1050 DEGREE / AIR					

484447

20 ga.

48" x 120"

316

SHEET